Work Order ID 102933 June-12-13 9:17:00 AM 2 8 1 0 A	*102	933*					Page 1
hune-12-13 9:17:00 AM Item ID: 646.3810 Revision ID: Item Name: Bracket	Accept	*N9000401	100*	Setu	p Start Stop	*N:	S1* S2*
Item Name: Bracket Start Date: 6/11/13 Start Qty: 10.00 / *1 Required Date: 6/11/13 Req'd Qty: 10.00 *1 Reference:		Cust Item ID: Customer:					
Approvals: Process Plan: MUJ Date: 13-06 QC: Date:	-	Date:	+ 	Run	Start Stop	*N!	R1* R2*
Sequence ID/ Operation Work Center 1D Description	Set Up/ Run Hours				-	Reject Number	Insp. Stamp
Draw Nbr Revision Nbr		•					
i 646.3800 N/C i 10 * 1 1 0* Memo Conventional Milling Machine L-Machine per DWG DWG REV: 2- deburr and break all sharp ed	0.00 0.00 ,	140/13/04/2	- · -	2/			
120 QC2- Inspect parts off machine FAI/FAIB *120* QC2- Inspect parts off machine FAI/FAIB Memo	0.00 - 0.00	MSP 13/07/23		2/			

Quality Control

Work Order: Part No. Rework Scrap Use-asia Use	DQA:			Date:			WORK ORDER NON	cc	MEGI		ור אדר			~~~\^\	ART
Part No. Sign & Process Part No. Supplier Process Part No. Pa	QA Closed:			Date:			WORK ORDER NON-	-CC	JNFOI	RIVIANCE / UP		ork Order up	odate only	A E	ROSPACE
Part No.	Work Orde	r -					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Cause Date Step Qty	Part N	o				-	Scrap Use-as-is		Thern	Machining noforming	Small Fab Finishing	⊣	d. Eng. Coor. re/Packaging	Q.	ıality
Cause Date Step Qty	Root	T				Desc	ription of work order update		nitial	Acti		Sign &		T	
Design Doc/Data			Date	Step	Otv	0000	·	ı					Verification	QC In	spector
Doc/Oata Equip/Tooling Handling/Pre Handling		_		<u> </u>	~-7			-		200					
FAULT CATEGORY Contain Folio/Program Content Folio/Program Content Contain Folio/Program Contain Contain Folio/Program Content Contain	· -	\dashv						Ì							
Handling/Pre Material Operator Operator	· ·	7													
Material Operator Offset/Setup Process Supplier Training Transport Unapproved Part Not Concentric Set-up Cracks Broken/Damage/Defect Broken/Damage/Defect Inspection Incomplete/Unqualified Part Lost/Missing Weld Wrong Stock Pulled Cuffs Contamination Inspection Strip in Tube Heat Treat Inspection Strip in Tube Marks/Chatter Drill Holes Off-set Turning Sequence Finish Out of Calibration Incomplete Inspection Incomplete Inspection Incomplete Inspection Incomplete Inspection Inspecti	 														
Opfrator Offset/Setup Process Supplier Transport Unapproved Bending Centre Not Concentric Cracks Broken/Damage/Defect Cracks Crimp/kink/Ripple/Wave Cuffs C		7								ii					
Offset/Setup Process Supplier Training Transport Unapproved Landing Gear General Bending Bending Bending Centre Not Concentric Cracks Broken/Damage/Defect Broken/Damage/Defect Hardware Cuffs Cuffs Contamination Cuffs Crushing Heat Treat Cut Too Short Inspection Strip in Tube Marks/Chatter Marks/Chatter Turning Sequence Pressure/Forced Folio/Program Outside Dimensions Pressure/Forced Grain Over/Under tolerance Set-up Temperature/Cure Inspection Incomplete/Unqualified Instructions Incomplete/Unqualified Part Lost/Missing Weid Wrong Stock Pulled Part Moved Wrong Stock Pulled Positioned Wrong Power Loss/Surge Other	<u>}</u>											,			
Process Supplier Training Transport Unapproved Bending	⊢	_													
Supplier Training Transport Unapproved Dending Gear General		\dashv													
Training Transport Unapproved FAULT CATEGORY Landing Gear	-	7		İ	İ										
Transport Unapproved		_						İ	;						
FAULT CATEGORY	 								;						
FAULT CATEGORY Landing Gear General Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up Cracks Broken/Damage/Defect Hardware Part Incorrect Temperature/Cure Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread Marks/Chatter Drill Holes Off-set Turning Sequence Finish Out of Calibration	` <u>}</u>														
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Cracks Broken/Damage/Defect Hardware Part Incorrect Temperature/Cure Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread Marks/Chatter Drill Holes Off-set Turning Sequence Finish Out of Calibration		_	_	t Concer	ntric			Н	_	- 		⊣	<u> </u>		
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread Marks/Chatter Drill Holes Off-set Turning Sequence Finish Out of Calibration		—1					•	-		re	 -	-1	-	- -1 :	ure/Cure
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Turning Sequence Finish Out of Calibration		_					1	\vdash		•					
			•			 	4			alibration					
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Work Orde June-12-13 9:1		02933		*102	933*						Page 2
Item ID: Revision ID: Item Name:	646.3810 Bracket			Accept	*N900	040	100)* s	etup Starr	171	S1* S2*
Start Date: Required Date: Reference:	6/11/13 6/11/13	Start Qty: 10,00 Req'd Qty: 10,00	*10* *10*		Cust Item I Customer:	D:					
Approvals:	Process P	lan: Dat	e:	Tooling:	Da	ate:		R	un Star	17	R1*
	QC:	Dat	te:	SPC (Y/N):	Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description QC8- Inspect parts - second chec	ck	Set Up/ Run Hours	Tool ID	Tool #	Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control		Memo		0.00	St	13-07-	23	_21_	Ø		. .
140		Outsource process-Anodize per	QSI017 4.1.10.1	0.00						DN 12	0726
140 Outsource4 Outsource process -	Anodize	Memo issue P/O to ATG:	20478	0.00					/	4 15	-O PSE
		1- Black Anodize as									
		2- PRIME AS PER Certification of Cor									
150 *4.5.0*		Receive & Inspect for Damage &	& Mat'l Certs	0.00				\bigcirc l $_{\rm I}$			\Box
150 Packaging		Memo		0.00				≪ I X			

Packaging

DQA:			Date:			NORY ORDER NON	c	ANEA1	DNAANCE / LIDD	ATE				`DART
QA Closed:			Date:			WORK ORDER NON-		JNFOI	NIVIAINCE / UPU		ork Order up	date only		AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	- ۱٥٠			· · · · · · · · · · · · · · · · · · ·		Rework Scrap Use-as-is Suspected Unapproved			Machining noforming	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
D ===4			T	Ι	Dana			l= isia l	0.41.	 .	Cian 0		· 1	
Root Cause		Date	Step	Qty	Desc	ription of work order update i or non-conformance		Initial nief Eng	Action Descript		Sign & Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FA	ULT CAT	regory					
Landir		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	at n Strip in	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Unquions Incomplete/Uncl ned/off center		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing /rong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	-		ist in Tub			Fit/Function		-1	Sequence					

Work Ord		02933		*102	2933*							Page 3
Item ID: Revision ID: Item Name:	646.3810 Bracket	. 		Accept	*N900	040	100)*	Setup	Start Stop	*N *N	S1*
Start Date: Required Date Reference:	6/11/13 e: 6/11/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:						. 17
Approvals:	Process Pl		Date:	Tooling: SPC (Y/N):		ate:		j	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center 155 *155* QC Quality Control	ID .	Operation Description QC5- Inspect part complete Memo	eness to step on W/O	Set Up/ Run Hours 0.00 27 0.00 3.	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*180 *180* Packaging Packaging		Identify as per dwg & Stoc Memo ***IDENTIFY	k Location: <u>ST5</u> 24 AS PER APICAL MPP-	0.00	# AND REV***					ŧ		13-08-1
1 QO QC Quality Control		QC21- Final Inspection - V	Vork Order Release	0.00				Λ	چس	- 13	-08 <u>-</u> W	70 V 3-8-19

DQA:		Date:				_						TAART
QA Closed:		Date:			WORK ORDER NON-	-C(ONFOI	RMANCE / U		Nork Order uj	odate only	AEROSPACE
					DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS	
Work Orde	er:					1			_	····		<u>, </u>
					Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	10				Scrap			Machining	Small Fab		d. Eng. Coor.	Quality
NICD N	اما				Use-as-is		inern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	NO				Suspected Unapproved]		Large Fab	Composite		Supplier	
Root				Desc	ription of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design											İ	
Doc/Data												
Equip/Tooling												
Handling/Pre		1	i				2.4					
Material							54					
Operator		1					* 6			ľ	1	
Offset/Setup						ĺ					!	
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	Bending				Bend	<u></u>	Folio/P	rogram	Ţ	Outside Dim	ensions	Pressure/Forced
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	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	re	L	Part Incorre	ct	Temperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave		Burrs	L	Inspecti	ion Incomplete/U	Inqualified	Part Lost/Mi	issing	Weld
	Cuffs				Contamination	L	Instruct	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
	Crushing				Countersink			ned/off center	<u> </u>	Positioned V		7
	Heat Trea	at			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
	Inspectio	n Strip in	Tube		Drawing		Misread					
	Marks/Cl	hatter			Drill Holes		Off-set					
	Turning S	Sequence			Finish		Out of (Calibration				
	Wave/Tw	vist in Tul	эe		Fit/Function		Out of	equence				

June-12-13 9:16:59 AM

Work Order ID:

102933

Parent Item:

646.3810

Parent Item Name:

Bracket

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Oty	Qty Issued	Date Issued	Status	
M7075T6A1.00X0.75X0.		Purchased	No No			110	l.	110.2000	0.1375	1.375		· -		+

7075T6 ANGLE 1.0" X .75" X .125" X .060"W

 Location
 Loc Qty
 Loc Code

 MAT036
 110.2

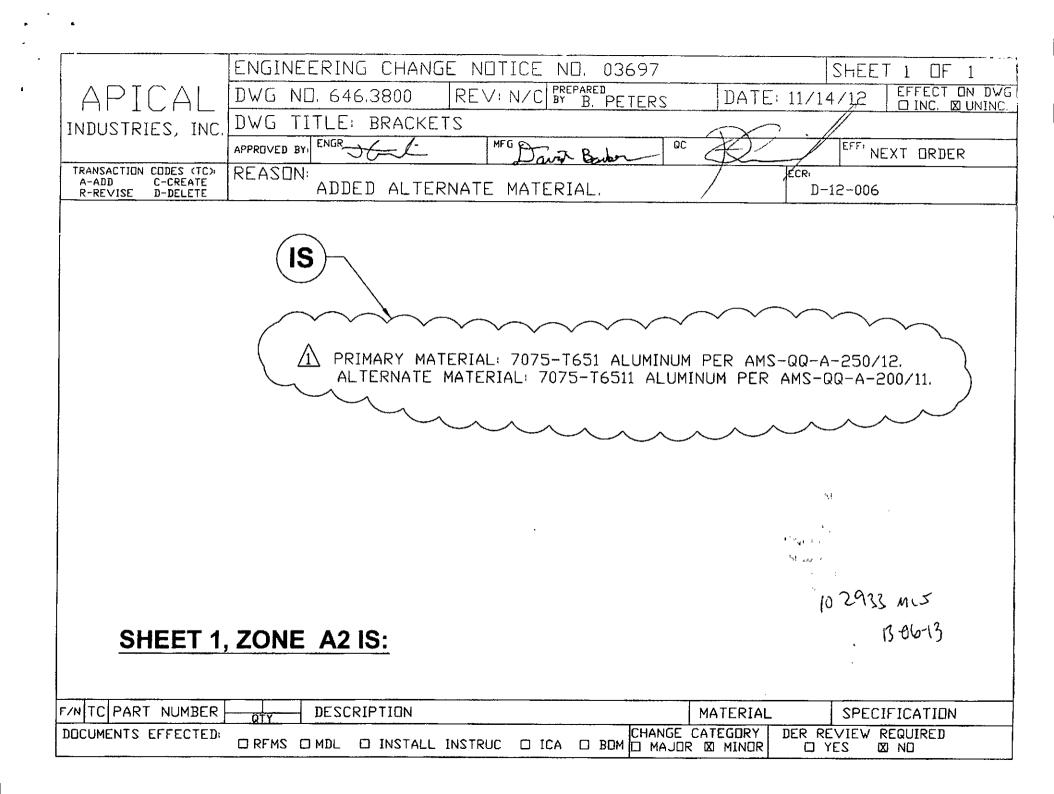
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Jan P 13/07/23

DQA:			Date:										•	N ADT
On Classed			Data			WORK ORDER NON	-C(ONFO	RMANCE / UP		ort Ordor ur	udata anlu -		AEROSPACE
QA Closed:			Date:			<u> </u>					ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	•					Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering
Part N	lo.					Scrap	']	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	•					Use-as-is			noforming	Finishing	=	e/Packaging		Other
NCR N	No.					Suspected Unapproved			· —	Composite		Supplier		
	•	-				· · · ·	,		° Ш					
Root					Desc	ription of work order update		Initial	Actio	on	Sign &		:	
Cause		Date	Step	Qty		or non-conformance	CH	nief Eng	Descrip	otion	Date	Verificatio	n	QC Inspector
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		Bending			L	Bend		Folio/F	Program		Outside Dim	ensions :		Pressure/Forced
1		Centre No	ot Concer	itric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	t		Temperature/Cure
		Crimp/Kii	nk/Ripple,	/Wave		Burrs		Inspecti	ion Incomplete/Unq	gualified	Part Lost/Mi	ssing		Weld
i [Cuffs				Contamination		Instruct	tions Incomplete/Un	nclear	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	√rong		
] [Heat Trea	at .			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misread	d					
] [Marks/Ch	atter			Drill Holes		Off-set						
[Turning S	equence			Finish		Out of (Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence					

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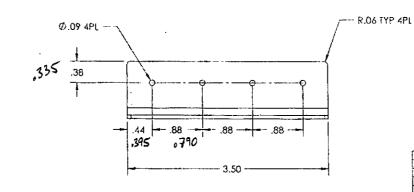
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- 25 FINISH: HARD ANODIZE JAW MI A-8625 TYPE 41. CLASS 2. COLOR SLACK: CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MILIT-2337/114PE 1 CLASS N
- 3. DEBURR AND BREAK ALL SHARP EDGES
- 4. IDENTIFY IAW MPP 120

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646.3810



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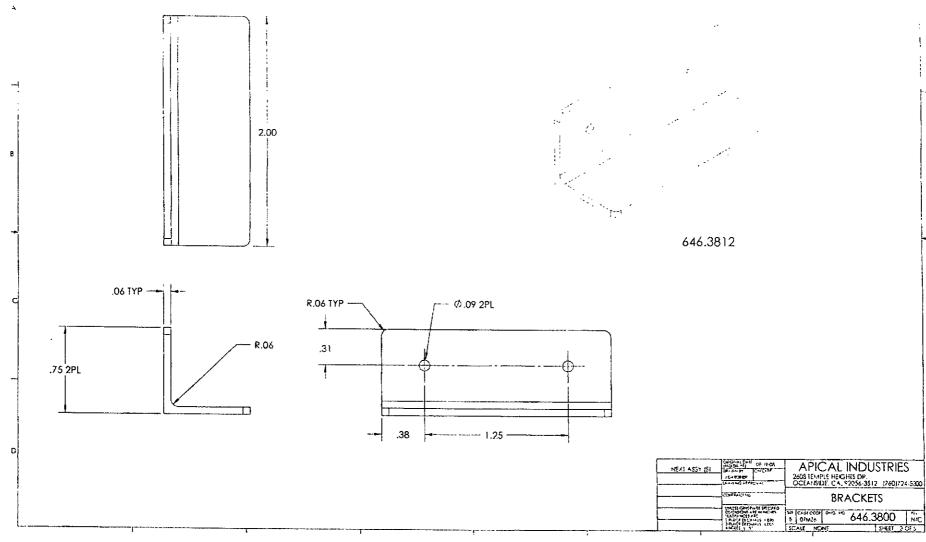
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646.3811 R.19 ---.19 APICAL INDUSTRIES
2609 TEMPRE HEIGHTS DR.
OCEANSIDE, CA. 92066-3512 (740)724-5300 **BRACKETS** STALE HESTE SPECT TOTAL

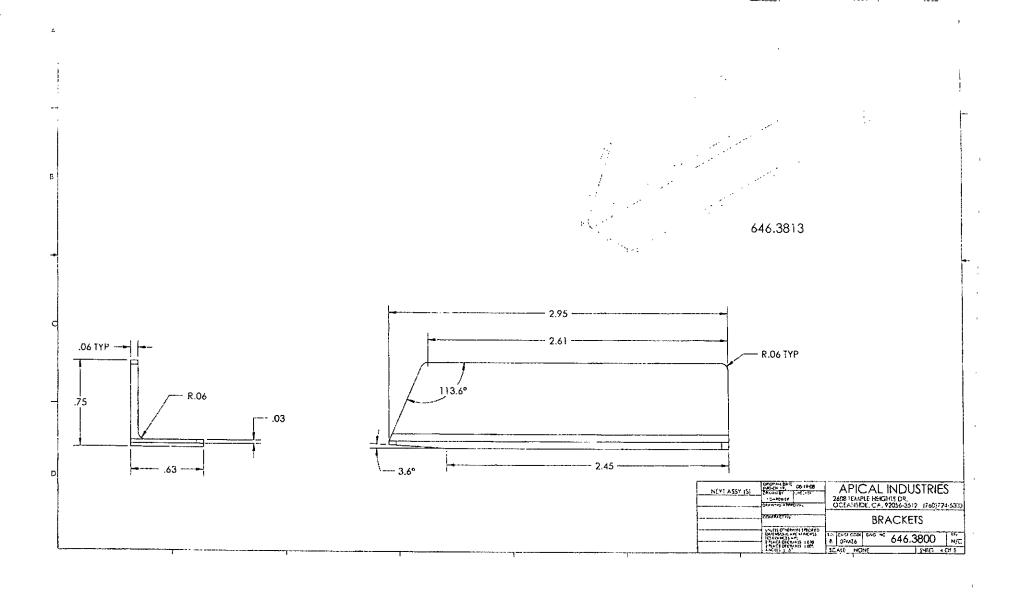
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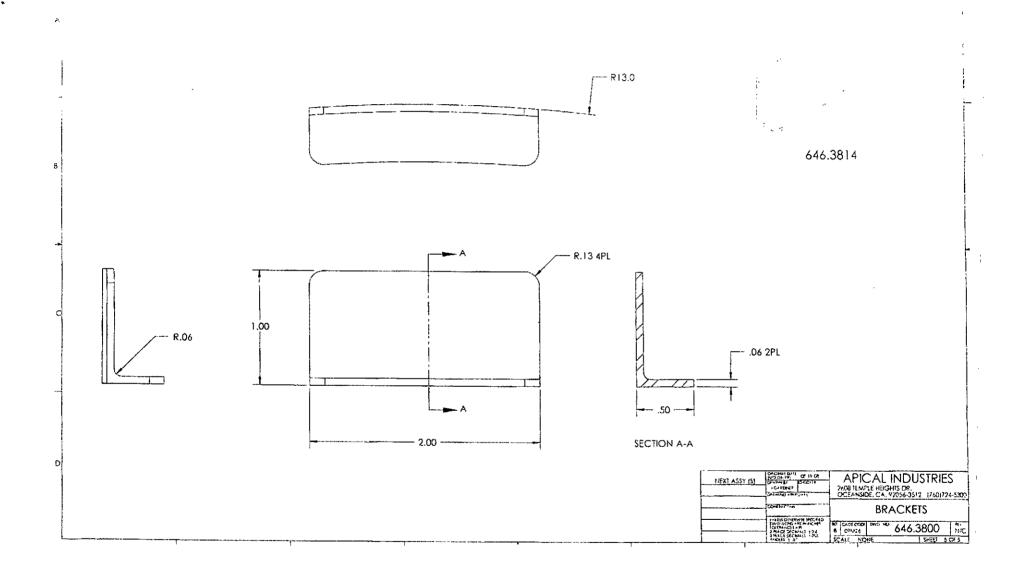
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DART AEROSPACE LTD	Work Order:	101933	
Description: Bracket	Part Number:	146,3810	
Inspection Dwg: [46, 3800 Rev: N/C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3,50	+ 0,010	3,495	/		1418-04	vern
\$ 0,090	+ 0,004 -	0,090	/		1100	///
0,38	+ 0,010	0,381	/		111	111
0.44	- 0,010	0,443	/		111	///
0,88	= 0,010	0,882	V		///	111
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			-		
Measured by:	los	Audited by:	A	Preliminary Approval:	
Date:	13/07/23	Date:	13-07-23	Date:	

Rev	Date	Change	Revised by	Approved
Ē	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15

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A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62561

Date: 13-Aug-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

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Terms		Ship Via
Quantity	Description	
21	Part: 646.3810	Rev:
ea		
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2	
	PRIME MIL-P-23377J TYPE I CLASS Job: 20130501	S N PO: 20678 Line:
	Certificate of Confo	ormance
	A.T.G. Industries certifies that all items in with all requirements, specifications and c	n this shipment are in conformance drawings referenced in the purchase order.
	ISO 9001 : 2008 REGINATE SALES-2010 TER DATE : 13/8/13 CERTIFIED SIGNATURE :	ISTERED RMS APPLY
	RECEIVER SIGNATURE :	
•		
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		•
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Tel: 613 632 9577

Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20678

Purchase Order Date 7/24/2013 PO Print Date 8/13/2013

Page Number 1 of 4

REVISE

Order From:

A.T.G. INDUSTRIES INC. 731 INDUSTRIELLE ROAD ROCKLAND, ON K4K 1T2 **CANADA**

VC-ATG001

DART AEROSPACE LTD Ship To:

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

613-446-4544

Yours ppd

Buyer

Brigitte Golden

Customer POID

Customer Tax #

10127-2607 Net 30

Terms Currency

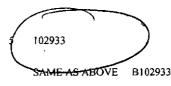
CAD

FOB

Destination-Collect

Ship Via: Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg 1D	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extenda Pri
4	104683	646.3513 Strut	8/2/2013		20.00	\$0.00	\$0.0
	•		Yes			•	
	Hard anodize IAW MIL A 8625 TYPE III CLASS 2 COLOR BLACK CARDINAL 4860-50 PRETREATMENT PRIMER IAW MIL-P-23377J TYPE 1 CLASS N B104683		8/2/2013				



646.3810 BRACKET

8/2/2013 Yes 8/2/2013

1.00 Sp13-8-

Line Total:

\$6.55

\$137.:

\$0.6

Line Total:

\$137.:

104680

646.3717 DOUBLER

8/2/2013

Yes

6.00

\$0.00

\$0.

SAME AS ABOVE B104680

8/2/2013

Note:

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